

Date: Monday, 23/02/2009 1:06:00 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RIB ASSY (BASKET LID, LH)
<b>Job Number</b> : 45946	
<b>Estimate Number</b> : 13665	
<b>P.O. Number</b> :	<b>Part Number</b> : D3838041
<b>This Issue</b> : 23/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3838 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 23/02/2009 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44772	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/02/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.23</u>	
<b>Comment</b> : Est Rev:A 08-12-01 new issue DD verified by:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



**Comment:** Qty.: 1.0833 f(s)/Unit Total : 2.1666 f(s)  
304 SQ Tube .75x.75x.065W  
batch: M110011

SAD 09-02-24 (2)

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



**Comment:** LARGE FABRICATION RESOURCE 1  
1- cut D3838-1 and D3838-3 rib as per dwg D3838  
2- c'sink hole as per dwg  
3- remove identification markings  
4- deburr

SAD 09-02-24

3.0

QC5

INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

SAD 09/02/24 (4)

4.0

D37591

Bushing



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing  
batch: B45794 → 2x

SAD 09/02/25

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



**Comment:** LARGE FABRICATION RESOURCE 1  
1- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M108775

SAD 09/02/25 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 1:06:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, LH)

Job Number: 45946

Part Number: D3838041

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 2- grind weld flush where indicated on dwg D3838 *JS*
- 3- weld D3759-1 bushing as per dwg D3838 *JS*
- 4- grind bushing weld flush as per dwg dwg D3838 *JS*
- 5- deburr hole if necessary *JS*

*JS 09/02/25 (2)*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 09-02-25 (1)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PD 09-02-25 (2)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Basket cell*

*PD 09-02-25 (2)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/02/26 JS*

*U 09.02.25*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

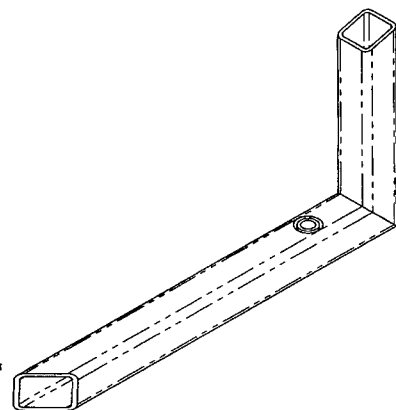
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

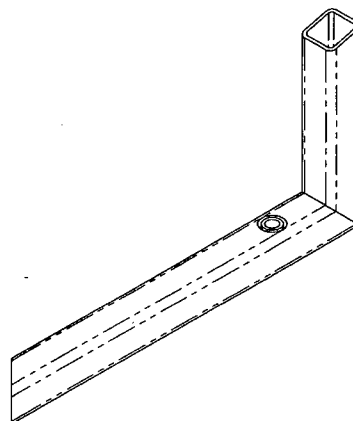
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 150946

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.54 lbs

RELEASED  
08/11/08

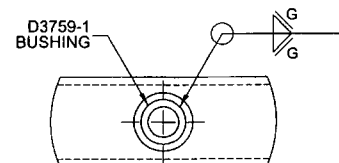
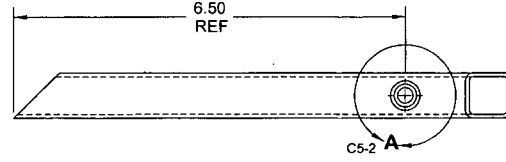
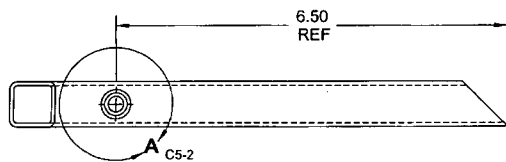
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REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

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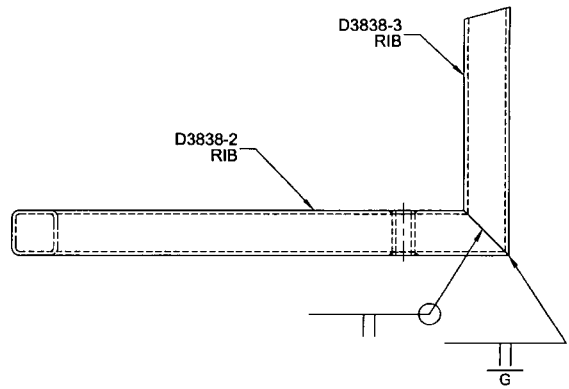
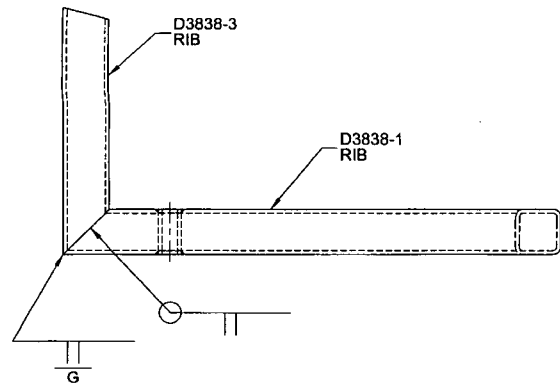
DRAWING NO. D3838 REV. A  
SHEET 1 OF 3

TITLE RIB ASSY (BASKET LID) SCALE NTS

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**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-041 RIB ASSY (BASKET LID, LH)**

**D3838-042 RIB ASSY (BASKET LID, LH)**

**RELEASED**  
08/10/08

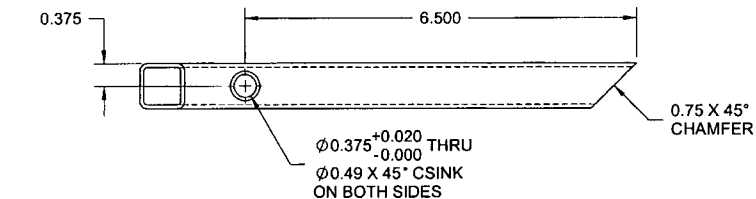
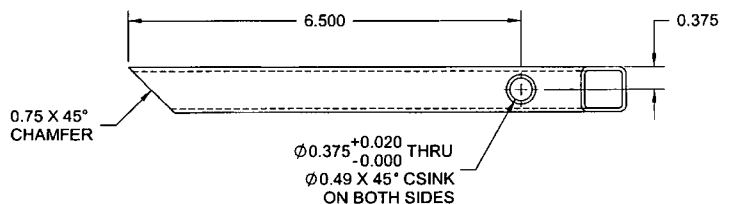
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WORK ORDER  
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MFG. APPR.		D3838	SHEET 2 OF 3
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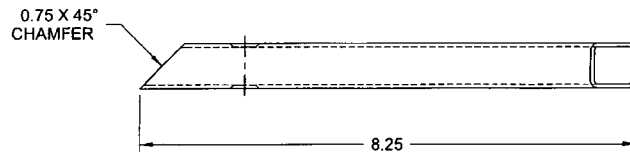
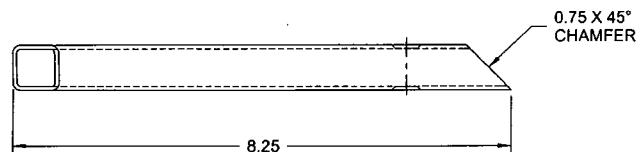
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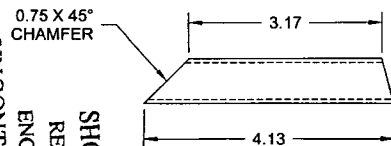


**D3838-1 RIB**

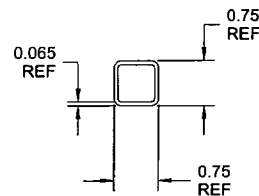
**D3838-2 RIB**

B

B



**D3838-3 RIB**



**TYPICAL SECTION VIEW**

**RELEASED**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-/-2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

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